

Date: Monday, 3/17/2008 12:00:09 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : DOUBLER
Job Number : 38058	
Estimate Number : 10296	
P.O. Number :	Part Number : D32203
This Issue : 3/17/2008 S.O. No. :	Drawing Number : D3220 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : A1
Previous Run : 38051D	Material :
Written By :	Due Date : 3/24/2008 Qty: 10 Um: Each
Checked & Approved By : <u>8 03 17</u>	
Comment : Est Rev: A New Issue 05-11-06 JLM	
Est: B 06.11.15 waterjet EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M2024T3S050 2024-T3 .050 sheet



Comment: Qty.: 0.6233 sf(s)/Unit Total : 6.2328 sf(s)
Material: 2024-T3 (QQ-A-250/4) 0.050" thick
(M2024T3S.050
Identify for D3220-3
Batch: 105646 B 8-3-19

(14)

2.0 WATER JET FLOW WATER JET



A1
A1

B 8-3-19



Comment: FLOW WATER JET

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



B 8-3-19



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

6 06/03/19

(14)

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Chemical Conversion Coat as per QSI 005 4.1

FL 08/03/19

(14)

6.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1

08/03/19

(14X)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: HD Date: 08/03/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/17/2008 12:00:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 38058

Part Number: D32203

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 234

8/3/19

SC

(14x)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(14)
12/08/03/20

Job Completion



2008/3/19

(14)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

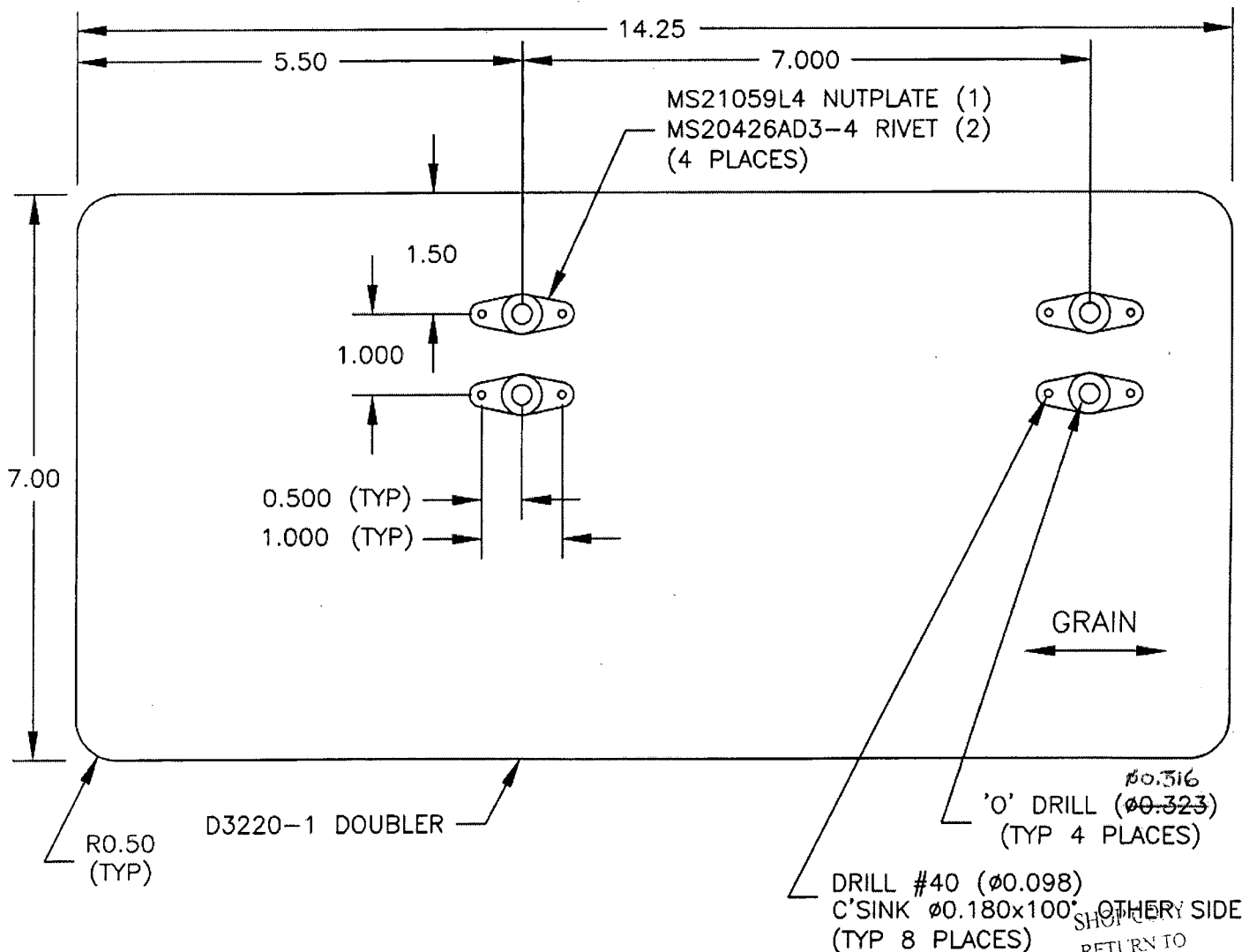
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN	<i>[Signature]</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3220	REV. A SHEET 1 OF 2
DATE	03.10.16			TITLE DOUBLER	SCALE 1:2
A	03.10.16			NEW ISSUE	
A1	<i>CP</i>	<i>[Signature]</i>	03.11.13	CORRECTED DIM.	

RELEASED
03.11.14



D3220-041 (SHOWN) / -042 (OPPOSITE) DOUBLER ASSEMBLY (D3220-1 DOUBLER)

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE
WORK ORDER
NO. 38058

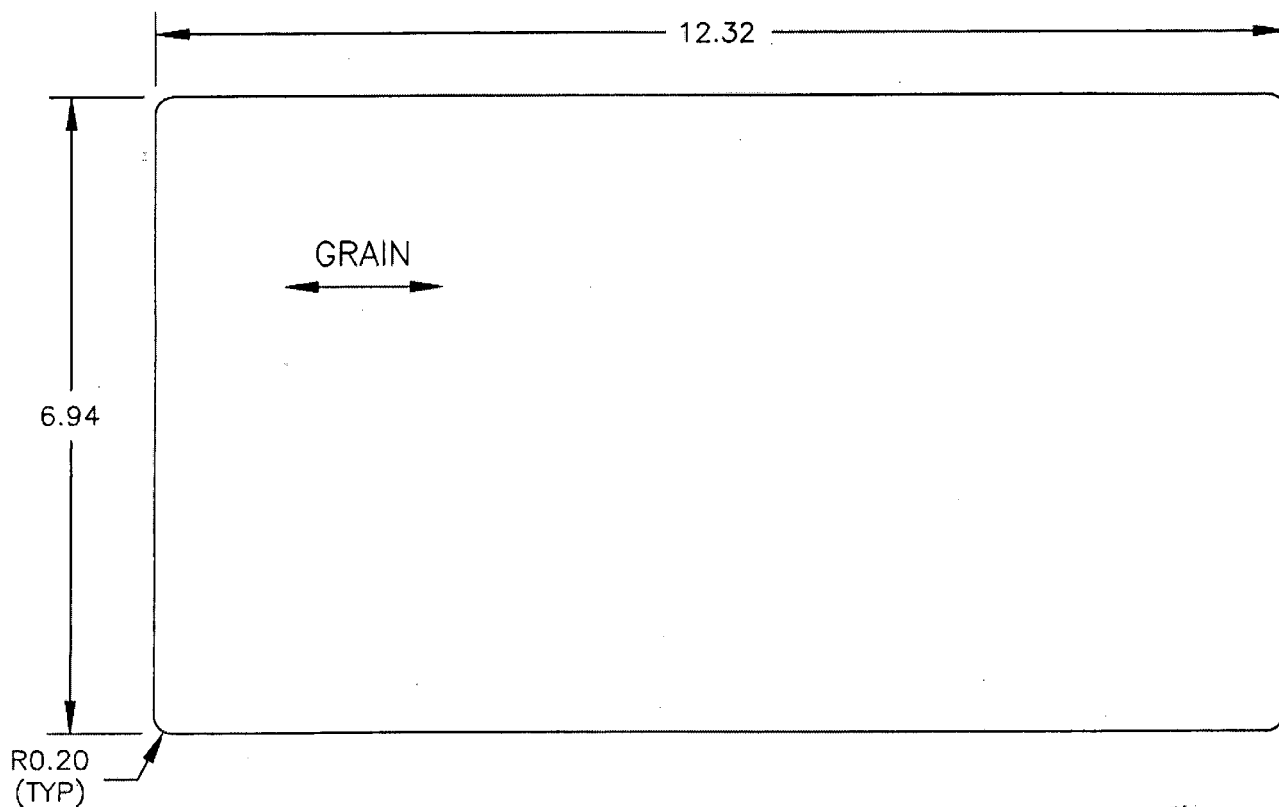
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DESIGN #	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3220	REV. A SHEET 2 OF 2
DATE 03.10.16		TITLE DOUBLER	SCALE 1:2

RELEASED
03.11.14 #



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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 38058

D3220-3 DOUBLER

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.050 THICK
(REF DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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